

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015741**Date Inspected:** 20-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face A
- 2). OBG Field Splice 2W/3W Weld ID: D1 & D2, Face B
- 3). OBG Field Splice 3W/4W Weld ID: D1 & D2, Face B
- 4). OBG Field Splice 5W/6W Weld ID: D1 & D2, Face A

- 1). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face A

The QAI periodically observed AB/F approved welder Fred Kaddu (2188) performing repair welding of on the A face of OBG Field Splice 1W/2W Weld ID: D1 & D2. The welding was per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position. SE QC Inspector Jesse Cayabyab was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1110A. The welding was in process at this location and work at this location appeared to be in general compliance with contract documents. See summary of conversations below.

- 2). OBG Field Splice 2W/3W Weld ID: D1 & D2, Face B

The QAI performed verification Visual & Magnetic Particle Testing (MT) of 10% of the lengths of OBG Field Splice 2W/3W weld ID: D1 & D2, Face B. The QAI inspected 500mm of Weld D1 from Y = 3750mm to Y = 4250mm and 500mm of weld D2 from Y = 4250mm to Y = 4750mm. The welds verified by the QAI appeared to

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## WELDING INSPECTION REPORT

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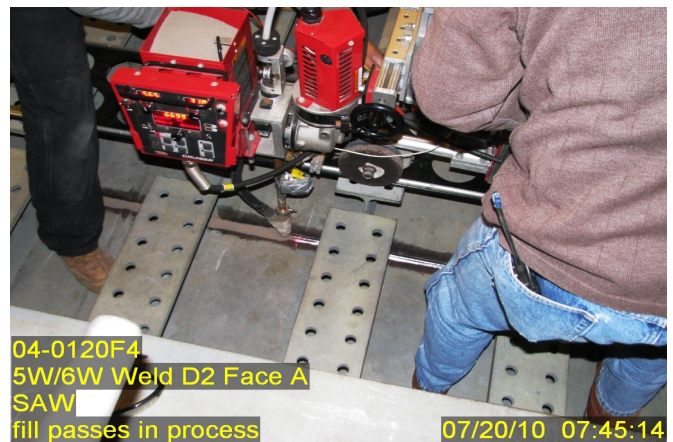
be in general compliance with contract documents. See Report of Magnetic Particle Testing Form TL-6028 generated by the QAI on this date.

### 3). OBG Field Splice 3W/4W Weld ID: D1 & D2, Face B

The QAI periodically observed ABF personnel performing grinding to prepare the groove in face B of the OBG Field Splice 3W/4W Weld ID: D1 & D2 for back welding. The QAI also randomly observed SE QC Inspector Steve McConnell performing MT of the groove before the commencement of welding. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1. 5-101 Rev. 4. The Approved AB/F welder Rory Hogan was busy with preparing the welding enclosure for the remainder of the shift.

### 4). OBG Field Splice 5W/6W Weld ID: D1 & D2, Face A

The QAI periodically observed the in process welding of the OBG Field Splice 5W/6W weld ID: D1 & D2 Face A per the Submerged Arc Welding (SAW) process in the 1G (flat) position by approved AB/F SAW operators Dan Ieraci (ID 3232) and Kenneth Chappell (ID 3833). See photos below. The SE QC Inspector Jesse Cayabyab was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-4042B-1. Welding of the fill passes was in process for the remainder of the QA Inspectors shift and work at this location appeared to be in general compliance with contract documents.



### Summary of Conversations:

The QAI arrived at the OBG Field Splice 1W/2W Weld ID: D1 & D2, Face A and observed SE QC Inspectors Jesse Cayabyab and Mike Johnson and approved AB/F welder Fred Kaddu. Mr. Cayabyab stated to the QAI that the welding being performed at this location on this date was to repair areas of insufficient fill that have remained since the original SAW was performed. Mr. Johnson added also that the QC NDE has not been performed to date because of the fact that the weld has not been visually acceptable.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

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**Inspected By:** Madison,Bert

Quality Assurance Inspector

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**Reviewed By:** Levell,Bill

QA Reviewer